

**Work Order ID 117131****\*117131\***

Page 1

April-24-14 9:54:42 AM

Item ID: D3589-049

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Aft Guide

Stop

**\*NS2\***

Start Date: 4/23/14 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 14-04-29

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3589	C								14-06-11 JSC

100 Weld per dwg A/R S.S. rod Batch: N/A 0.00**\*100\***

Large Fab

Memo 0.00

Large Fab 1- Form, assemble and weld as per dwg D3589 QSI004

A/R Stainless Steel rod batch: M125054

4

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Memo 0.00

Quality Control

⑥ 14-06-13

DAS  
9  
989

120 QC5- Inspect part completeness to step on W/O 0.00

**\*120\***

QC

Memo 0.00

Quality Control

⑥ 14-06-13

DAS  
9  
989

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design							noted		
Doc/Data							noted		
Equip/Tooling							noted		
Handling/Pre							noted		
Material							noted		
Operator							noted		
Offset/Setup							noted		
Process							noted		
Supplier							noted		
Training							noted		
Transport							noted		
Unapproved							noted		

FAULT CATEGORY									
Landing Gear	General		Folio/Program		Outside Dimensions		Pressure/Forced		
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>				
	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>				
	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>				
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>				
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>				
	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Other <input type="checkbox"/>					
	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>						
	Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Off-set <input type="checkbox"/>						
	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>						
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>						
	Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>							

Work Order ID 117131

April-24-14 9:54:42 AM

\*117131\*

Page 2

Item ID: D3589-049

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Aft Guide

Stop

\*NS2\*

Start Date: 4/23/14 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location:

WAC02

0.00

DAS  
28  
9-89

JUN 13 2014

\*130\*

Packaging

Packaging

Memo

0.00

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Quality Control

Memo

0.00

MLJ 14-06-16

MLJ 14-06-16

DQA:

Date:



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only 

Work Order: _____ Part No. _____ NCR No. _____				<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved											
<b>FAULT CATEGORY</b>											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function			<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence							

# Picklist Print

April-24-14 9:54:45 AM

Page 1

Work Order ID: 117131

**\*117131\***

Parent Item: D3589-049

**\*D3589-049\***

Parent Item Name: Aft Guide

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-30 new issue DD verified by:ec  
12.07.23 AS PER REV.C DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3589-19		Manufactured	No			100	Each	8.0000	1	4			

**\*D3589-19\***

Aft Guide Plate

Location	Loc Qty	Loc Code
WA002	8	
	8	

D3589-21

**\*D3589-21\***

Latch Guide

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

Location	Loc Qty	Loc Code
WA002	8	
	8	

DQA:

Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
Part No. _____		
NCR No. _____		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	<table border="0" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="4" style="width: 100%; text-align: center;"> <b>General</b> </td></tr> <tr> <td style="width: 25%;"><input type="checkbox"/></td><td style="width: 25%;"><input type="checkbox"/></td><td style="width: 25%;"><input type="checkbox"/></td><td style="width: 25%;"><input type="checkbox"/></td></tr> <tr> <td>Bending</td><td>Bend</td><td>Folio/Program</td><td>Outside Dimensions</td></tr> <tr> <td>Centre Not Concentric</td><td>BOM/Route</td><td>Grain</td><td>Over/Under tolerance</td></tr> <tr> <td>Cracks</td><td>Broken/Damage/Defect</td><td>Hardware</td><td>Part Incorrect</td></tr> <tr> <td>Crimp/Kink/Ripple/Wave</td><td>Burrs</td><td>Inspection Incomplete/Unqualified</td><td>Part Lost/Missing</td></tr> <tr> <td>Cuffs</td><td>Contamination</td><td>Instructions Incomplete/Unclear</td><td>Part Moved</td></tr> <tr> <td>Crushing</td><td>Countersink</td><td>Misaligned/off center</td><td>Positioned Wrong</td></tr> <tr> <td>Heat Treat</td><td>Cut Too Short</td><td>Mislabeled</td><td>Power Loss/Surge</td></tr> <tr> <td>Inspection Strip in Tube</td><td>Drawing</td><td>Misread</td><td><input type="checkbox"/></td></tr> <tr> <td>Marks/Chatter</td><td>Drill Holes</td><td>Off-set</td><td><input type="checkbox"/></td></tr> <tr> <td>Turning Sequence</td><td>Finish</td><td>Out of Calibration</td><td><input type="checkbox"/></td></tr> <tr> <td>Wave/Twist in Tube</td><td>Fit/Function</td><td>Out of Sequence</td><td><input type="checkbox"/></td></tr> </table>	<b>General</b>				<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	Bending	Bend	Folio/Program	Outside Dimensions	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Crushing	Countersink	Misaligned/off center	Positioned Wrong	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Inspection Strip in Tube	Drawing	Misread	<input type="checkbox"/>	Marks/Chatter	Drill Holes	Off-set	<input type="checkbox"/>	Turning Sequence	Finish	Out of Calibration	<input type="checkbox"/>	Wave/Twist in Tube	Fit/Function	Out of Sequence	<input type="checkbox"/>
<b>General</b>																																																					
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Wave/Twist in Tube	Fit/Function	Out of Sequence	<input type="checkbox"/>																																																		

8

7

6

5

4

3

2

1

D

D

C

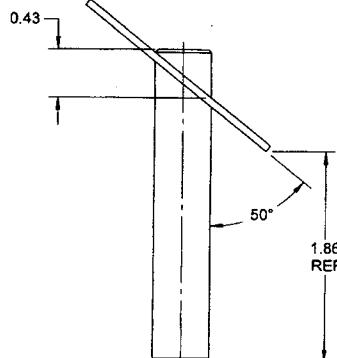
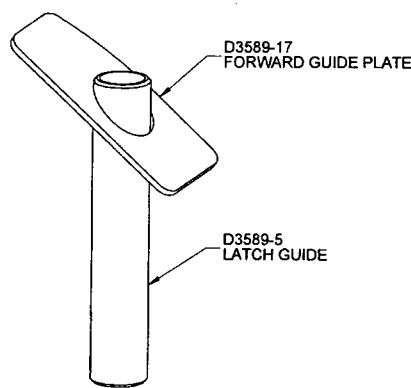
C

B

B

A

A



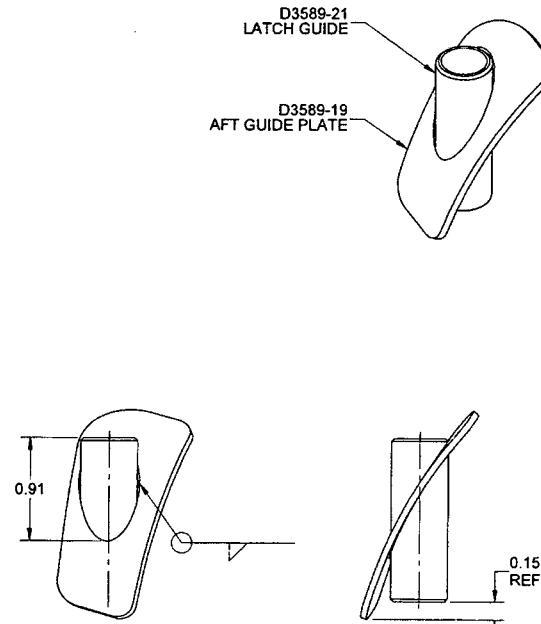
△ D3589-047 FORWARD GUIDE

D3589-047/-049 NOTES.

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
  - D3589-047 = 0.08 lbs
  - D3589-049 = 0.05 lbs
- 8) WELDING: PER DART QSI 004

ITEM	QTY -047	QTY -049	P/N	DESCRIPTION
	X		D3589-047	FORWARD GUIDE
	X		D3589-049	AFT GUIDE
1	1		D3589-5	LATCH GUIDE
2	1		D3589-17	FORWARD GUIDE PLATE
3		1	D3589-19	AFT GUIDE PLATE
4		1	D3589-21	LATCH GUIDE

117131 ML5  
14-04-29



△ D3589-049 AFT GUIDE

RELEASED  
2012-07-16  
M

DESIGN	1	DART AEROSPACE LTD
DRAWN	1	HAWKESBURY, ONTARIO, CANADA
CHECKED	1	
MFG. APPR.	1	
APPROVED	1	
DE APPR.	1	
DATE	12.07.04	SCALE NTS
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